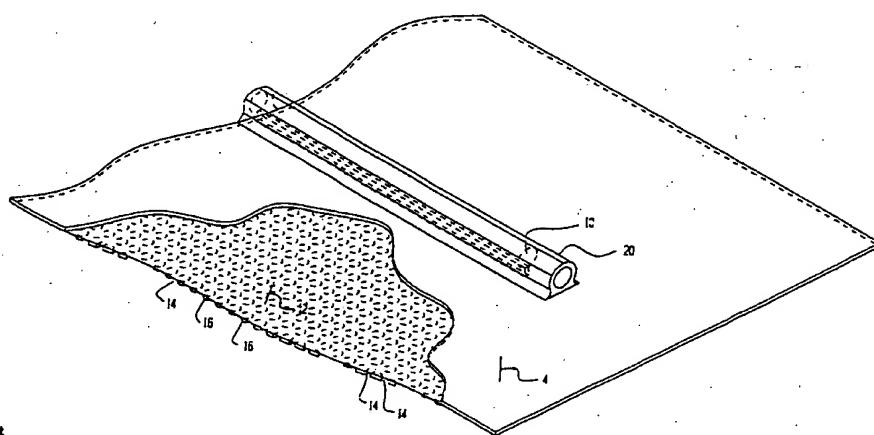


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(71) Applicant: <b>SEEMANN, William [US/US]; P.O. Box 3449, Gulfport, MS 39505 (US).</b>	
(74) Agent: <b>NORCROSS, Alexander; P.O. Box 776, Gulfport, MS 39502-0776 (US).</b>	

(54) Title: **UNITARY VACUUM BAG AND PROCESS FOR MAKING SAME**



**(57) Abstract**

A unitary vacuum bag (4) for forming of a fiber reinforced composite article having molded in resin distribution means (10) formed to a specific article. The vacuum bag (4) is constructed upon a mold which forms the base for the construction of the desired fiber reinforced composite article. The bag (4) contains an open sided, resilient main distribution conduit (10) running laterally along the long axes of the vacuum bag with branch conduits (16) to provide for long distance flow of resin to all parts of the composite article and elastomeric tube receptacles (20). A multiplicity of cross channels (14) are formed on the inner surface of the bag from a pattern of dots (16), covering most of the area under which the fiber lay up is placed within the mold. A mold on the mold is used to form a vacuum bag (4) from an elastic material and the vacuum bag is used to form a composite article.

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## DESCRIPTION

### **Unitary Vacuum Bag and Process For Making Same**

10

#### TECHNICAL FIELD

This invention relates to the field of transfer molding techniques for the production of fiber reinforced resin composite structures. In particular, it relates to processes and apparatus for molded, vacuum bag construction of fiber reinforced resin composite structures of various shapes.

#### BACKGROUND ART

Fiber reinforced resin composite structures have taken many shapes and forms, including tubes or conduits as employed in the chemical processing industry, flat sheets and compound shapes as employed in boat building and extensive curved shapes as employed in aerospace. In these constructions a fiber reinforcement is laid up against a mold to provide the desired shape. This fiber reinforcement may be pre-wetted with resin, forming a "pre-preg" structure. More often a dry lay up of fiber is placed upon a mold and then wetted through by resin. The resin is allowed to set and cure upon the mold to form the fiber reinforced resin composite structure. Critical problems involved in this process include the uniform distribution of resin into the fiber, the elimination of air voids and bubbles, elimination of areas not wetted by resin within the fiber structure, and reduction of the use of excess resin or waste of resin in the process. The apparatus and processes, used to make these structures therefore vary considerably depending upon the specific shape and form of the structure to be produced.

A common technique is the so called vacuum bag technique which has been used to form fiber reinforced plastic structures. In vacuum bag techniques,

flexible sheets, liners or bags are used to cover a mold which contains the dry or wet fiber lay up. The edges of the flexible sheet are clamped or sealed against the mold to form a sealed envelope surrounding the lay up. A catalyzed liquid plastic or resin is introduced into the envelope, into the interior of the bag, to wet the fiber, 5 and a vacuum is applied to the bag interior via a vacuum line to collapse the flexible sheet against the fiber and surface of the mold. The vacuum serves to shape the article to the mold, to draw the resin through the fiber mat, completely wetting the fiber, and to remove any air which would form voids within the completed article.

10 The vacuum is continued while the plastic wetted fiber is pressed and cured against the mold to form the desired shaped fiber reinforced plastic structure. Since the entire resin curing process occurs within a sealed bag, and a continuous application of vacuum draws off all fumes through filters, resin fumes from the process are prevented from escaping into the ambient work space.

15 My prior U.S. Patent 5,052,906 and U.S. Patent 4,902,215 disclose vacuum bag structures in which distribution media are placed within the vacuum bag, surrounding the fiber lay up, in order to enhance the uniform distribution of resin through the composite upon the application of a vacuum. In order to enhance the separation of the completed molded fiber reinforced plastic structure from the mold 20 and the bag, and to reduce the chances of contamination of the surface of the structure, peel plies, in the form of porous thin sheets which do not adhere to resin, are provided between the distribution media and the fiber lay up.

In the cited patents, fiberglass reinforced laminates are shown that have very desirable resin to fiber ratios and uniform mechanical properties. The vacuum bag 25 process produces high strength structures in very complex shapes including boat hulls. However, each article created in this manner requires a separate set up of vacuum bag and distribution media; while this is desirable for one of a kind production, it is not the most efficient method of molding repeated identical structures.

In early vacuum bag structures, such as British Patent No. 944,955, the reinforced fiber structure is laid upon a single cavity mold, the mold covered by a flexible sheet or vacuum bag and the outer edges of the sheet sealed upon the mold to leave a space containing the dry fiber lay up. The liquid resin is introduced via supply line located at the top center of the bag and the vacuum is drawn on the bag by a vacuum line located at a peripheral edge of the mold. The collapse of the bag under the vacuum presses and forces the resin and fiber against the contour of the mold. A viscous resin require squeezing or rolling to distribute the resin through the fiber.

Other patents have suggested channels to distribute the resin through the fiber including U.S. Patent 4,312,829 to Fourcher and U.S. Patent 2,913,036 to Smith.

In U.S. Patent 4,942,013 to Palmer, et al. a structure is shown in which the resin is introduced through an opening at one end of the mold and a vacuum is drawn from the other end of the mold, thus drawing the resin laterally across and then through the fiber lay up. A second fiberglass layer is required to aid in the distribution of the resin.

#### DISCLOSURE OF INVENTION

This invention is the formation of an integral vacuum bag, preferably of silicone rubber, having molded therein a resin distribution means formed to the specific article to be made. Alternatively, vacuum conduits can also be provided at the periphery of the bag, causing the bag to be adapted to any number of mold shapes without requiring vacuum conduits to be placed in the mold. The inventive bag is constructed upon the base mold which forms the base for the construction of the desired fiber reinforced plastic article.

The article contains an open sided, resilient main distribution conduit running laterally along the long axes of the desired vacuum bag with branch conduits, depending upon the shape of the mold, to provide for long distance flow of resin to all parts of the article to be made. A multiplicity of cross channels are then formed on the inner surface of the bag, covering most of the area in which the

fiber lay up is placed within the mold. These cross channels can be formed from a pattern of multiple, variegated small dots, pillars, cones, or pyramid shape structures, which, under vacuum, leave a multiplicity of small channels to run along the inner surface of the silicone rubber vacuum bag. This pattern of distribution 5 channels covers most of the fiber lay up, except for a perimeter area which is left without channels to insure resin flow into rather than across the fiber lay up. Optionally, along the periphery of the vacuum bag, outside the area of the fiber lay up, is a continuous circumferential, non-collapsing vacuum outlet conduit.

Each of the major vacuum and resin conduits is provided with an inlet tube 10 connection formed of an elongated thickened wall opening into which a vacuum tube or resin supply tube may be inserted and which is amenable to being sealed with a tacky tape or similar seal. This permits the resin introduction and vacuum draw to be through standard thick walled plastic tubing which can be inserted into the bag without the necessity of connectors.

15 The bag is sealed against the mold using appropriate tacky tape edge seals, although in some circumstances the bag itself has sufficient adhesion to be sealable.

The bag is most suitable for the repeated manufacture of a number of identical fiber reinforced plastic articles. The base mold can be used as structure 20 upon which the vacuum bag is built. Either a wax lay up or an actual article covered with suitable separating materials can be laid up upon the mold and covered with a peel sheet. A resin distribution medium can then be laid over the peel sheet. This medium is then covered with a flexible open rod or tube running along the desired location of the resin distribution channels and the vacuum 25 receiving channels. This set up is then sprayed or coated with a separation compound.

The vacuum bag of the invention is created by applying a viscous silicone rubber compound in multiple coats over the completed lay up, building the bag up to a suitable thickness. The silicone rubber is then cured and peeled away from 30 the distribution medium and the positive tubing. The resulting silicone rubber

structure contains an integral resin distribution medium and vacuum channels adapted to vacuum forming of the article. It may be readily reused as a vacuum bag for the repeated manufacture of fiber reinforced articles.

In the use of the inventive vacuum bag it is necessary only to lay up a dry fiber preform against the mold in the desired orientation and thickness. A peel layer or peel sheet may be applied over the fiber. The inventive silicone rubber vacuum bag is placed over the peel sheet and fiber, and sealed to the mold. A vacuum is applied and then resin introduced until resin runoff within the vacuum channels indicates total impregnation of the article. The article then is allowed to set until the resin cures.

The bag may then be readily peeled from the article, cleaned of any residual resin and reused.

As can be seen, once such a bag is made for a specific article, it can be reused without the necessity of laying up individual distribution media and channel structures for each repeated construction of copies of the fiber reinforced article.

It is accordingly the primary object of the invention to disclose a uniform vacuum bag structure which can be readily manufactured for a particular article and mold, and which integrates the features of resin distribution and vacuum draw off with the sealing and pressing features of a standard vacuum bag.

It is the further object of the invention to disclose a vacuum bag which is conformably formed to provide the most uniform possible pressure structure for the manufacture of a fiber reinforced composite structure against a mold.

It is the further object of the invention to disclose a vacuum bag which assures uniform resin distribution throughout the fiber lay up for a vacuum bag molded fiber reinforced composite structure.

It is the further object of the invention to disclose a vacuum bag which may be rapidly reused for the rapid production of a series of identical fiber reinforced composite structures on a mold.

It is the further object of the invention to disclose a process for creating a vacuum bag adapted to a particular mold and a particular desired composite

structure, for rapid, accurate, and repeatable production of multiple copies of the fiber reinforced composite structure.

#### BRIEF DESCRIPTION OF DRAWINGS

Fig. 1 is a side view of a fiber lay up using the invention.  
Figure 2 is a top view of an embodiment of the invention.  
Figure 3 is a sectional view of the invention, including a view of a conduit.  
Figure 4 is a cut away view of a second embodiment of the invention.

#### BEST MODE FOR CARRYING OUT THE INVENTION

The invention is best shown in comparison to my prior US Patent 4,902,215, incorporated herein by reference in full. In side view in figure 1, I show a dry lay up for manufacture of a fiber composite structure 1, utilizing the inventive vacuum bag 4.

The composite 1 is formed on a rigid mold 6, for this illustrative purpose a flat smooth table surface forming a backing for the fiber composite article 1. A pattern of dry reinforcing fibers 2, such as fiberglass or carbon fibers, is laid on the mold 6. The shape of the mold 6 determines the shape of the final structure 1, and thus the mold 6 can be curved or of any desired shape, as will be illustrated below.

In the prior art, a peel sheet 3 would be placed over the fiber lay up 2, and then a distribution layer laid on the peel sheet to enhance flow of resin to impregnate the lay up 2. A resin entrance chamber would be centrally placed on the lay up with a communicating resin distribution chamber to communicate resin flow to the distribution layer. A vacuum outlet, either in the rigid mold or on the outer periphery of the lay up, would communicate with a source of vacuum. A vacuum bag or sheet would then be placed over the entire assembled lay up and distribution layers, and sealed around its perimeter to the mold. A vacuum, applied to the vacuum outlet, would draw the vacuum bag against the lay up. The vacuum

both draws the resin throughout the fiber lay up, and presses the resin impregnated lay up against the rigid mold to smoothly form the desired fiber reinforced shape.

It should be appreciated that this process requires individual labor to set up the same distribution layers, chambers and vacuum bag in separate steps, even though identical articles may be desired. There are no economies of scale in this process, and every article manufactured is made as though it were a one of a kind article.

In the invention, a preformed vacuum bag with integral resin distribution piping and distribution pattern, and optional vacuum piping, is created for the composite article which is to be formed. To create this inventive vacuum bag 4, the desired rigid mold 6 is first covered with a model of the desired finished fiber composite structure 1. This can be a master article, manufactured as stated above, or a wax or wood model, or some combination of fiber composite base article and wax or wood additions, to create the external shape of the desired article 1. This master article pattern is then coated with a separation layer, such as a 50% soap and water mixture. The separation layer is allowed to completely dry.

A reverse master resin distribution pattern, of one of the various forms as illustrated in my prior '251 patent Figures 3-7, is then applied over the outer surface of the model article 1. This reverse master pattern may be the mirror image of any pattern of continuous small channels 14, preferable running in two cross wise directions. Such a reverse master pattern could include a repeated pattern of cylindrical dots, or small regular polyhedral solids 16. It can also include the pattern of spaced apart rows, crossed by an overlying pattern of spaced rows at right angles to the first rows.

Over the reverse master pattern is laid a hollow piping structure of significantly greater cross sectional area. Such a structure should run the long length of the desired article 1, and for a wide or complex shape, preferably has branch conduits so that no part of the article 1 is more than forty-eight inches from a conduit.

Optionally a second conduit structure 24 is placed as a continuous ring around the bag, communicating for vacuum flow from the mold 6, just outside the perimeter B of the pattern master article 1.

This distribution pattern and the conduit(s) are in turn coated with a  
5 separation layer which is allowed to dry.

The inventive vacuum bag 4 is then formed by repeated applications of an elastomer, such as a viscous, curable silicone rubber, or other peeling, resin resistant curable elastomer, to cover the assembled master pattern 1, building up a layer of elastomer with greater thickness over the hollow conduit structures 10, 24.

10 Thicker extensions 19 extending outward from these conduit structures may be provided, to extend beyond the outer limits of the article 1, and to be completely coated with elastomer. The second conduit structure 24 may be reinforced by embedding a helical coil or spring 25 into the vacuum conduit 24 wall to prevent collapse of the conduit 24 upon application of a vacuum from a vacuum source 26.

15 A suitable material for forming vacuum bag 4 is Dow Corning Tooling Elastomer - THT™. This elastomer is translucent, helping in monitoring the progress of the construction of the vacuum bag. This material has a viscosity of 450 poise, which helps give good brushability, and cures, when catalyzed, at room temperature within 24 hours.

20 After cure, the vacuum bag 4 is peeled from the underlying pattern article 1. The recommended elastomer has high tear strength, reducing the chance of damage to the finished bag. The bag may be additionally reinforced by fiber reinforcement, such as nylon fibers, applied as a hand lay up during the construction of the bag.

25 The conduit sections produce, within the finished bag 4, a pattern of elongated flow conduits 10 communicating with the inner surface 12 of the vacuum bag 4. These flow conduits 10 communicate for fluid flow with a resin distribution pattern 14, formed from the imprint of the reverse master resin distribution pattern. This pattern 14 will normally be a cross hatch of small channels at right angles to  
30 each other, separated by a repeated pattern of small bumps 16 on the inner

surface of the bag. These bumps 16 may be pyramidal shapes, or spherical, or small cylindrical or square pillars. Any such repeated pattern of bumps 16 that will support the channels 14 against complete collapse under a vacuum is suitable, so that the bump pattern will press against the fiber lay up 2 but the channels 14 will remain open a spaced distance for resin flow.

The bag build up around the piping extensions creates hollow cured elastomeric tube receptacles 20 on the bag exterior, which connect for fluid flow with the interior elongated flow conduits 10 in the inner surface 12 of the bag 4. These tube receptacles 20 accept and seal an inserted plastic tube 22 for connection with a resin dispensing system 23, and, where a surrounding vacuum flow conduit 24, with reinforcing wall helical springs 25, has been formed in the bag 4, with tubing 22 connected to a vacuum source 26.

The resulting bag 4 is a monolithic vacuum bag structure having embedded resin conduits 10 and distribution channels 14 which have been customized to the article 1 desired to be made on a specific rigid mold 6. This inventive bag 4 can therefore be repeatedly used to make accurate, identical fiber reinforced articles 1. In each case it is necessary only to make the fiber lay up 2 against the mold 6, add the peel layer 3 if desired, and then cover the lay up with the vacuum bag 4 of the invention, sealing the bag to the mold with tacky seal 30.

The described material for making the inventive bag 4 does not adhere to resins. This has the advantage that the bag 4 can be easily peeled from the composite structure 1 and any residual resin in the distribution channels 10,11 formed in the bag 4 may be easily removed. It has the disadvantage that it is difficult to seal the bag 4 to the mold 6 using the tapes of the prior art vacuum bag process. However, those skilled in the art know of a "tacky tape" which may be used to seal the bag to the mold, and Schnee Moorehead Adhesives Part #5601 has been reported to be suitable. Alternatively, a suitable adhering material, such as teflon, may be embedded in the perimeter of the vacuum bag during manufacture and cure, to provide a suitable surface to seal the bag. In some circumstances, such as where the mold is a planar smooth surface, such as a metal topped table,

the silicon rubber vacuum bag may adhere to the table sufficiently to provide a suitable seal.

It is recognized that the design of the bag 4 should be such that the resin is distributed from the center of the article A to the periphery B, and the vacuum 5 should be drawn from the periphery B. This set up serves to purge any air leaks from the seals at the periphery of the vacuum bag, preventing air bubbles or voids in the resin impregnated fiber. This flow arrangement can easily be established by the set up of the article master pattern during the construction of the bag 4.

The construction of the bag 4 is otherwise highly variable to meet the shape 10 of the desired article and mold. For example in my prior patent '215 Figure 8, a section of the large structure such as a boat hull is shown. In such a structure, the flow of resin is aided by gravity to the periphery of the bag. If for any reason the mold should be inverted, than several resin inlets could be provided, and resin supplied to each in turn as the resin flows centrally outward through the reinforcing 15 fiber lay up. The translucency of the vacuum bag is advantageous in that the progress of the resin can be visually followed by manufacturing personnel so as to sequence the supply of resin.

The vacuum outlet 26 does not have to be molded into the bag. Providing 20 vacuum conduits 24 in the bag 4 may be useful on complicated molds 6, or where the mold 6 cannot be provided with an internal vacuum outlet 26 and distribution conduit 24. Otherwise the vacuum conduits 24 may be in the mold 6, and the bag 4, when created, is extended to cover the vacuum conduits 24, the distribution pattern 14 in the bag inner surface running almost to the position of the mold's vacuum conduits.

25 It can thus be seen that the invention provides a vacuum bag which has considerable operational advantages for repeated manufacture of fiber reinforced articles against molds, providing a unitary vacuum cover to both seal and press the resin into the fibers, as well as providing an integrated means for uniform distribution of resin to the fiber lay up and a uniform vacuum suction. Further the 30 vacuum bag of the invention, being conformably built for the specific mold and

article to be constructed, has none of wrinkling and folds of the prior art planar sheets used for vacuum bags, and therefore control of the surface smoothness of the manufactured fiber reinforced article is improved.

The invention extends past the specific embodiments described to include those equivalent structures and processes as will be apparent to those skilled in the art from the claims.

CLAIMS

- 1- A vacuum bag for forming a fiber reinforced composite structure by vacuum bag molding comprising:
  - in a unitary structure:
    - a vacuum bag having a periphery and an inner surface;
    - a resin distribution conduit in said inner surface, connected with a repeating, internal plurality of small channels on said inner surface;
    - said unitary structure covering the fiber reinforced composite structure on a rigid mold.
- 10 2- The vacuum bag of claim 1 further comprising:
  - a vacuum conduit in said inner surface, extending continuously around the perimeter of said vacuum bag between said plurality of channels and the edge of the bag.
- 15 3- The vacuum bag of claim 1 further comprising:
  - means, fluidly communicating with said resin distribution conduit, for sealing engagement with a resin dispensing tube.
- 20 4- The vacuum bag of claim 1 further comprising:
  - a vacuum conduit in said inner surface, extending continuously around the perimeter of said vacuum bag between said plurality of channels and the edge of the bag;
    - means, fluidly communicating with said tubular resin distribution conduit, for sealing engagement with a resin dispensing tube; and
    - means, fluidly communicating with said tubular vacuum conduit, for sealing engagement with a tube connection to a vacuum source.
- 25 5- The vacuum bag of claim 1 further comprising:
  - a second, repeating, internal plurality of small channels on said inner surface, extending perpendicular to said small channels.
- 30 6- In the process of forming a vacuum bag for the formation of a fiber reinforced composite structure by vacuum forming against a mold, the improvement comprising:

forming said bag of a material fit over said structure and said mold;  
forming within said bag on the surface proximate to said structure one or  
more connected conduits for distribution of resin;  
forming on said surface of the bag a pattern of protrusions extending from  
said conduits to near the perimeter of said structure, said protrusions forming  
channels for the distribution of resin under a vacuum drawn within said bag.

5 9- The process of claim 8 further comprising:

forming within said bag, on said proximate surface, a continuous conduit  
extending around the bag outside the perimeter of said structure.

10 10- A vacuum bag for forming a fiber reinforced composite structure by vacuum  
bag molding comprising:

in a unitary curable elastomer structure:

a vacuum bag having a periphery and an inner surface;  
a tubular resin distribution conduit in said inner surface, connected

15 with a

repeating, internal plurality of small channels on said inner surface;  
said unitary curable elastomer structure being formed to fit, covering the  
fiber reinforced composite structure on a rigid mold.

11- The vacuum bag of claim 10 further comprising:

20 a tubular vacuum conduit in said inner surface, extending continuously  
around the perimeter of said vacuum bag between said plurality of channels and  
the edge of the bag.

12- The vacuum bag of claim 10 further comprising:

means, fluidly communicating with said tubular resin distribution conduit, for  
25 sealing engagement with a resin dispensing tube.

13- The vacuum bag of claim 10 further comprising:

a tubular vacuum conduit in said inner surface, extending continuously  
around the perimeter of said vacuum bag between said plurality of channels and  
the edge of the bag;

means, fluidly communicating with said tubular resin distribution conduit, for sealing engagement with a resin dispensing tube; and

means, fluidly communicating with said tubular vacuum conduit, for sealing engagement with a tube connection to a vacuum source.

5 14- The vacuum bag of claim 10 further comprising:

a second, repeating, internal plurality of small channels on said inner surface, extending perpendicular to said small channels.

15- A process for forming a fiber reinforced composite structure against a rigid mold by vacuum bag forming comprising:

10 fitting a negative mold resin distribution pattern over a model of the fiber reinforced composite structure fitted to the mold;

fitting a negative mold tubular resin distribution conduit to the fiber reinforced composite structure over said negative mold resin distribution pattern;

15 molding an elastomeric covering over said fiber reinforced composite structure, said negative mold resin distribution pattern, and said negative mold tubular resin distribution conduit;

thereby forming a vacuum bag having an integrated resin distribution conduit and pattern on its inner surface, conformably fit to said fiber reinforced composite structure;

20 providing means for dispensing resin into said resin tubing and for drawing a vacuum from said bag; and

repeatedly,

forming a fiber lay up on said mold;

sealing said bag to said mold over said fiber lay up

25 drawing a vacuum from said bag and dispensing resin into said bag, whereby said fiber lay up is impregnated with resin and cured into a finished object.

16- The process of claim 15, said providing means for drawing a vacuum comprising:

fitting a negative mold tubular vacuum removal conduit on the mold outside the perimeter of the fiber reinforced composite structure.

17- In the process of forming a vacuum bag for the formation of a fiber reinforced composite structure by vacuum forming against a mold, the improvement comprising:

forming said bag of a cured silicon rubber conformable to said structure and said mold;

forming within said bag on the surface proximate to said structure one or more connected tubular conduits for distribution of resin;

10 forming on said surface of the bag a pattern of repeating protrusions extending from said tubular conduits to near the perimeter of said structure.

18- The process of claim 17 further comprising:

forming within said bag, on said proximate surface, a continuous tubular conduit extending around the bag outside the perimeter of said structure.

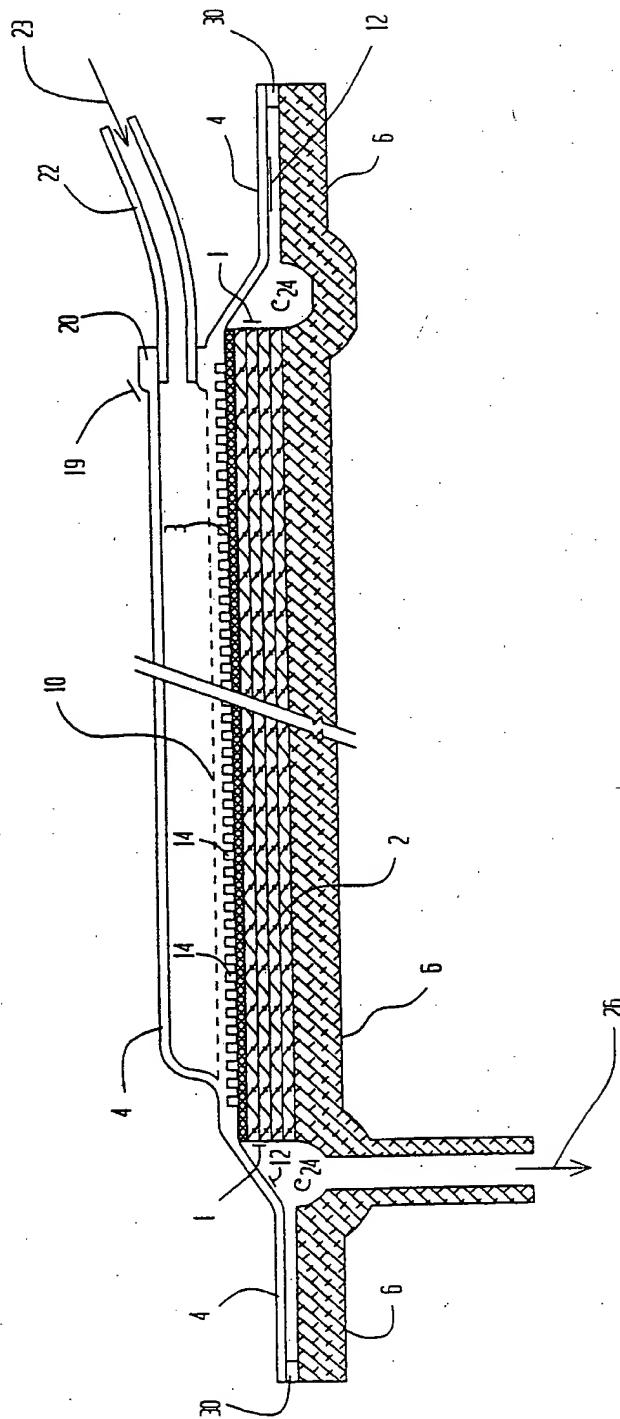


Fig. 1

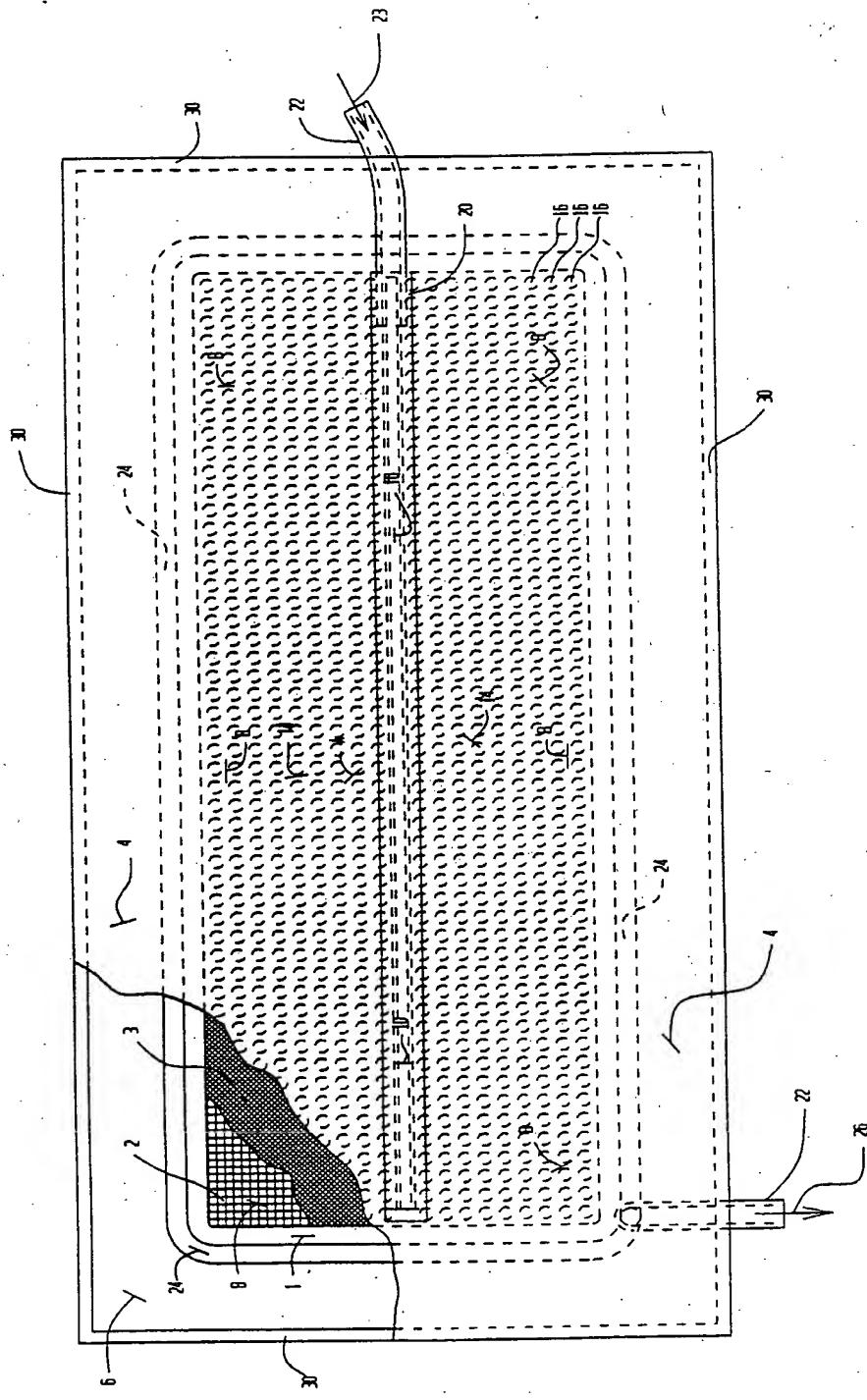


Fig. 2

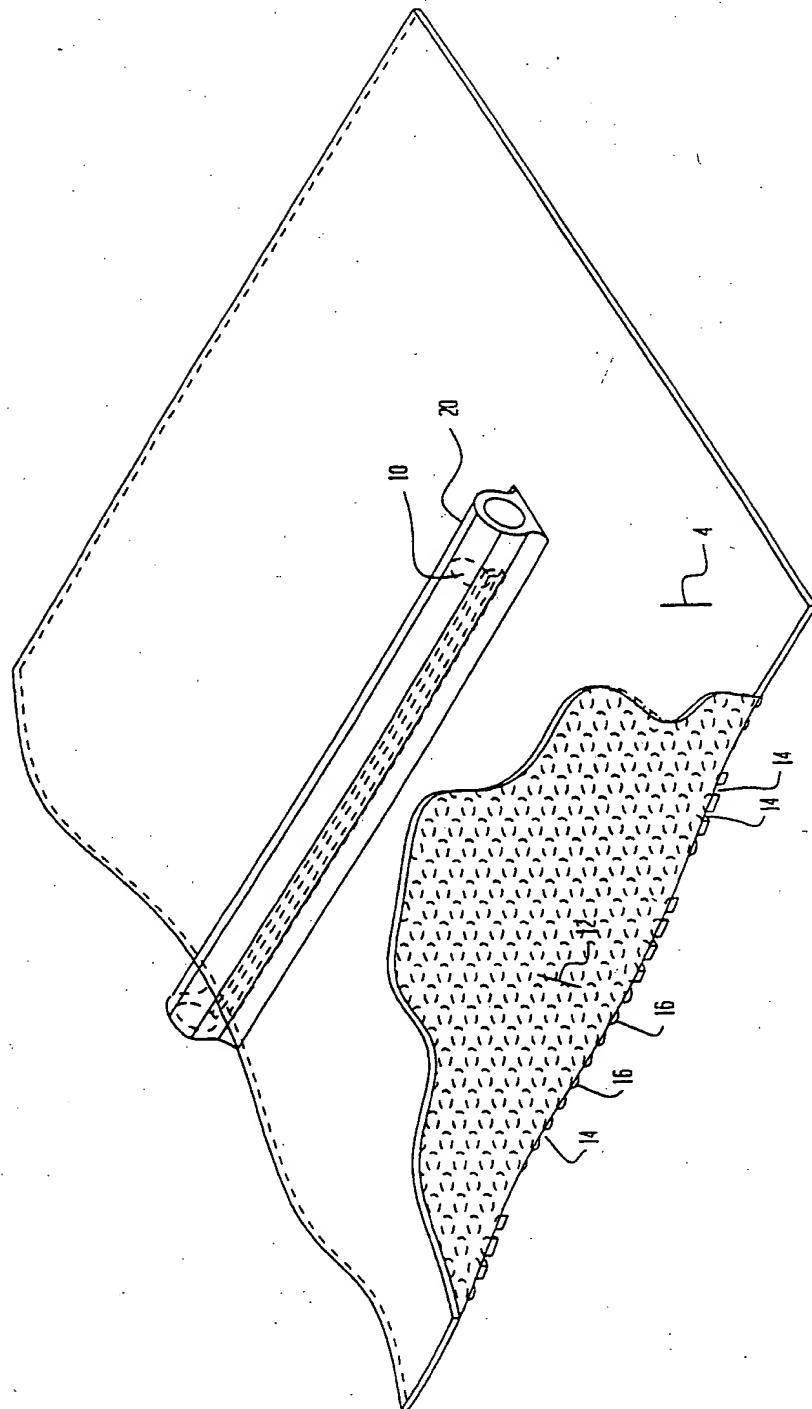


Fig. 3

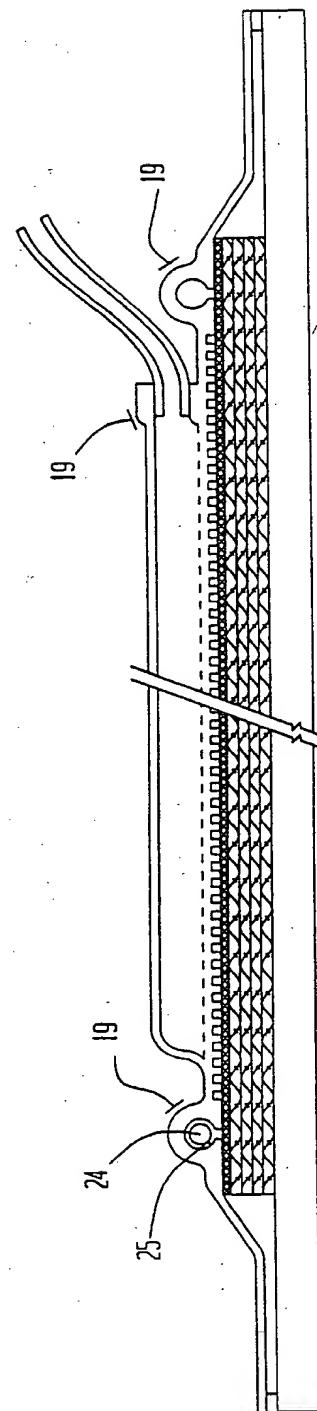


Fig. 4

## INTERNATIONAL SEARCH REPORT

International application No.  
PCT/US94/01367

## A. CLASSIFICATION OF SUBJECT MATTER

IPC(5) :B29C 33/40, 45/14, 45/17, 67/14  
US CL :264/225, 257, 316, 571; 425/112, 389, 405.1

According to International Patent Classification (IPC) or to both national classification and IPC

## B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

U.S. : 264/225, 257, 258, 316, 510, 511, 571; 425/85, 110, 112, 388, 389, 405.1

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US, A, 2,913,036 (SMITH) 17 November 1959, figures 1-3.	1-5, 10-14
A	US, A, 3,146,148 (MITCHELLA ET AL.) 25 August 1964, figures 2-5, col. 5, line 64 to col. 6, line 17.	1-6, 10-18
A	US, A, 4,132,755 (JOHNSON) 02 January 1979, figures 1 and 5-7.	1-5, 10-14
A	US, A, 4,312,829 (FOURCHER) 26 January 1982, figures 1-2.	1-5, 10-14
A	US, A, 4,822,436 (CALLIS ET AL.) 18 April 1989, figure 1 and col. 2, line 25 to col. 3, line 63.	6, 15-18

Further documents are listed in the continuation of Box C.  See patent family annex.

Special categories of cited documents:	"T"	later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
"A" document defining the general state of the art which is not considered to be part of particular relevance	"X"	document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
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Date of the actual completion of the international search.

12 JULY 1994

Date of mailing of the international search report

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Commissioner of Patents and Trademarks  
Box PCT  
Washington, D.C. 20231  
Facsimile No. (703) 305-3230Authorized officer *Debbie Weller*  
JAY H. WOO  
Telephone No. (703) 308-0651

## INTERNATIONAL SEARCH REPORT

I      International application No.  
PCT/US94/01367

## C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US, A, 4,902,215 (SEEMANN, III) 20 February 1990, figures 1-3 and 9.	1-5, 10-14
A	US, A, 4,942,013 (PALMER ET AL.) 17 July 1990, figure 1.	1
A	US, A, 4,975,311 (LINDGREN) 04 December 1990, figures 3-4, and col. 4, lines 51-67.	1-5, 10-14
A	US, A, 5,052,906 (SEEMANN) 01 October 1991, figures 2-3.	1-5, 10-14
A	JP, A, 50-3098 (KYODO PRINTING CO. LTD.) 31 January 1975, figures 1-2.	1
A	JP, A, 3-162933 (YAMAHA CORP.) 12 July 1991, figures 1-2.	1-5, 10-14